

VIBRATORY FINISHER WITH BLASTING NOZZLE

ABSTRACT OF THE DISCLOSURE

A process and apparatus wherein a bulk quantity of parts is positioned in a channel-like treating chamber which is subjected to vibration to cause the flowable mass of parts to slowly undergo a corkscrew-like tumbling movement. One or more nozzle arrangements are positioned adjacent the treating chamber so that each nozzle has its discharge orifice position closely adjacent the flowing bulk mass in the chamber to effect high-velocity blasting of a selected region of the flowing mass. The nozzle emits a high-velocity spray which is defined by a carrier medium such as air having small abrasive particles or grit embedded therein. The abrasive spray contacts a concentrated area which has relatively small transverse and longitudinal extent over the flowing mass in the chamber. Due to its high-velocity discharge, the spray is effective in penetrating at least partway into the depth of the flowing mass to abrade the parts.